

Work Order ID 75206-2

October-18-11 4:11:08 PM

75206

Page 1

Item ID: D3199-3

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

Required Date: 04/11/2011 Req'd Qty: 90.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.S

Date: 11/10/18 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3199

E

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: E

Prog Rev: E

Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

split

90

90

90

Push ASAP!!!

Need to ship Oct 24

BIT-10-19

114

114

BIT-10-19

Work Order ID 75206

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75206

Page 2

Item ID: D3199-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Bracket, Fwd LH

Stop

NS2

Start Date: 18/10/2011 Start Qty: 90.00

90

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

90

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sulio/25

counters
(414)
OS/019

130

Bend as per dwg
Small Fab

0.00

130

Brake NC

Memo

0.00

Brake NC

SD 11/10/26

(90)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Sulio/26

counters
(490)
OS/019
-3

Work Order ID 75206

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Page 3

Item ID: D3199-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

90

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

90

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1=40
3200F
2:10

90 x 8 m 11/10/20

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

90 BR 11-10-20

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

90 11/10/20 88x

Work Order ID 75206

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75206

Item ID: D3199-3
Revision ID:
Item Name: Bracket, Fwd LH
Start Date: 18/10/2011 Start Qty: 90.00
Required Date: 04/11/2011 Req'd Qty: 90.00
Reference:

90
90

Accept

N9000040100

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/
Work Center ID

180
180
QC

Operation
Description
QC21- Final Inspection - Work Order Release

Set Up/
Run Hours
0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Quality Control

Memo

0.00

11/10/26
mk
11-10-26

Picklist Print

October-18-11 4:11:12 PM

Page 1

Work Order ID: 75206

75206

Parent Item: D3199-3

D3199-3

Parent Item Name: Bracket, Fwd LH

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 90.00

Required Qty: 90.00

Comments:

IPP RevA: RevC-prelim DD verified by:EC
11.03.31 as per ecn 11-531 DD ver:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

137.0795

0.1673

15.84947

M304S20GA

**

18-10-19

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

137.0795

116623

0.2

117550

8.363

117933

43.3442

118400

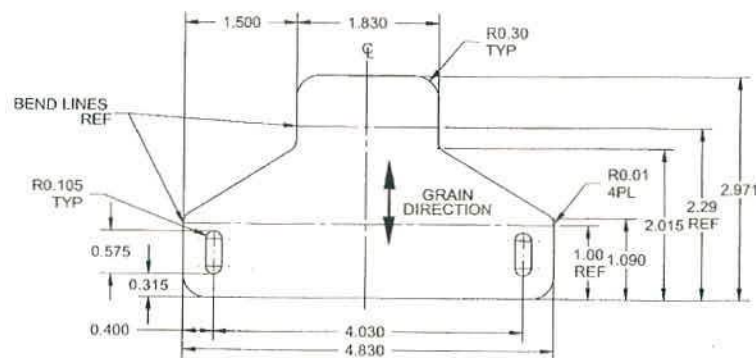
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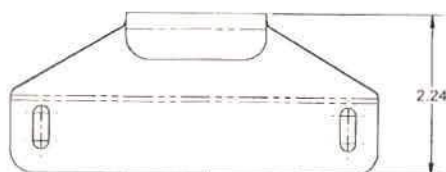
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117933

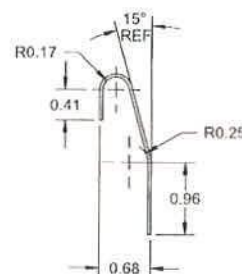
114



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F



NOTES:

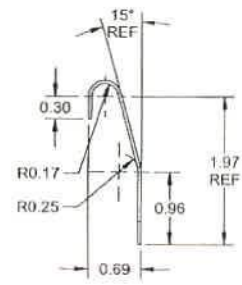
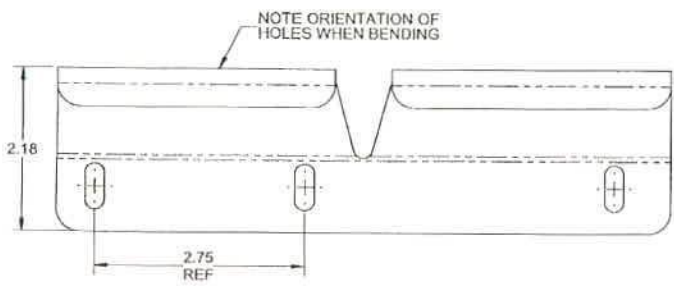
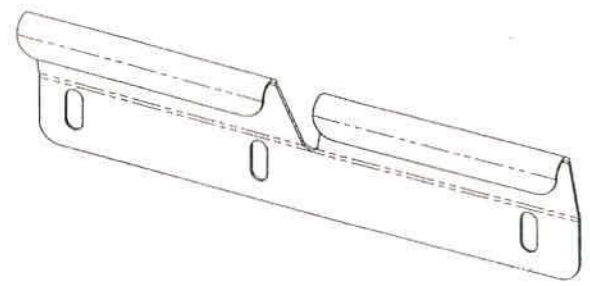
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

E	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PART11-79	MB	11.03.21
C	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142, ADD FINISH, UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE		11.07.11	
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RELEASED
2011-07-18
MB

75206 M.L. 5
11/10/10

75206

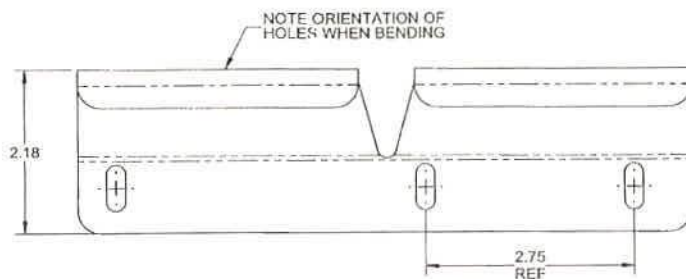


D3199-3 BRACKET
MADE FROM D3199-3F

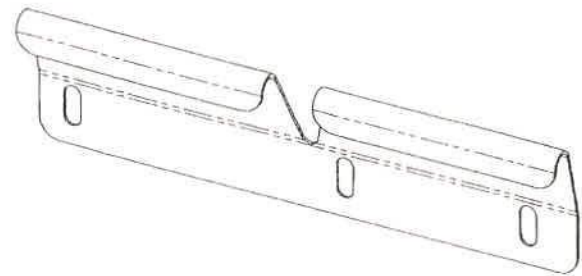
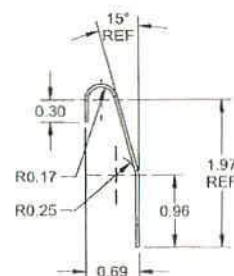
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2011-07-18
WIP

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3199 TITLE BRACKET <small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD</small>	REV. E SHEET 2 OF 4 SCALE NTS
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DATE 11.07.11	

75206



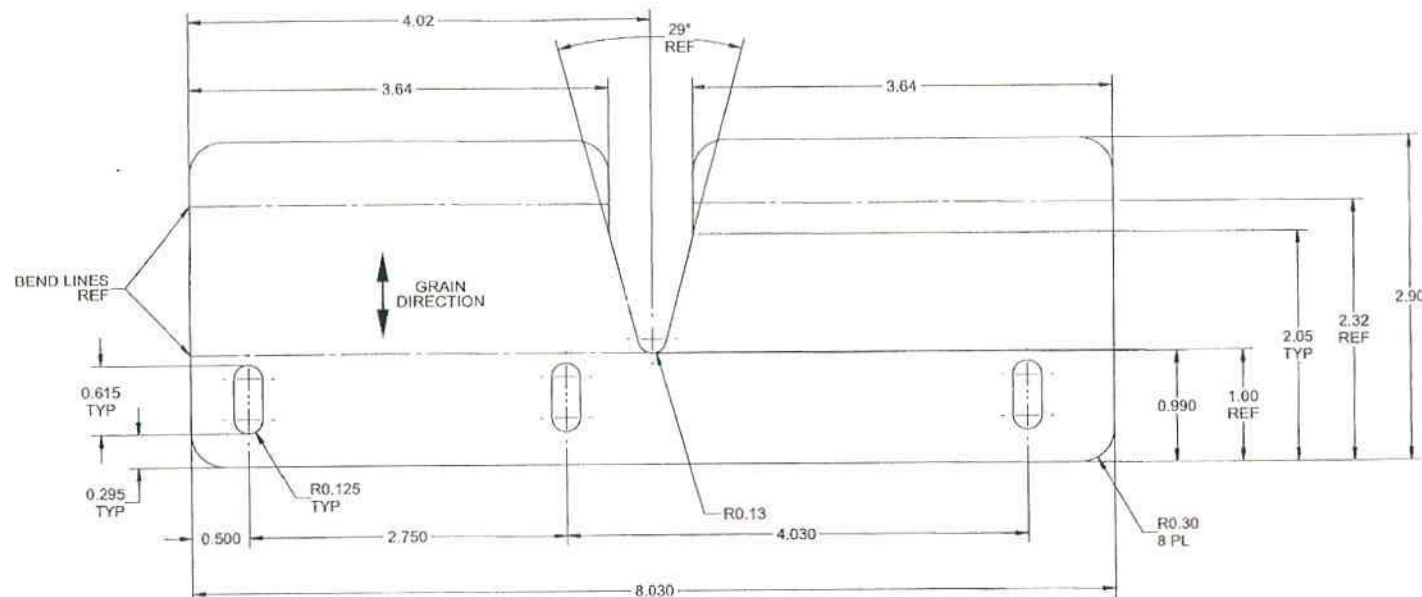
D3199-4 BRACKET
MADE FROM D3199-3F



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2011-07-18
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CHECKED		DRAWING NO. D3199	REV. E
MFG. APPR.		SHEET 3 OF 4	
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75206



D3199-3F FLAT PATTERN

RELEASED
2011-07-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. E
CHECKED		D3199	SHEET 4 OF 4
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DART AEROSPACE LTD

Work Order: 75706

Description: BRACKET

Part Number: D3199-3

Inspection Dwg: D3199-3 Rev: 1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.64	$\pm .030$	3.640	X		V	
4.02	$\pm .030$	4.022	2			
2.90	$\pm .030$	2.904	2			
1.000	$\pm .030$	1.003	2			
.614	$\pm .030$.618	2			
.795	$\pm .030$.794	2			
.500	$\pm .030$.501	2			
2.750	$\pm .030$	2.754	2			
4.030	$\pm .030$	4.033	2			
8.030	$\pm .030$	8.039	2			
.040	$\pm .030$.044	2			

Measured by: B

Date: 11-10-19

Audited by: S

Date: 11/10/19

Prototype Approval:

Date:

Rev	Date	Change
A		New issue

Revised by	Approved
KJULM	